

14/09/2009 3:01:25 PM

## Process Sheet

U-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
: 47598		
: 10023		
	Part Number	: D205634041
: 29/04/2009 S.O. No. :	Drawing Number	: D2580 REV D
rev. : NC	Project Number	: N/A
at Issue : / /	Drawing Revision	: F
Previous Run : 47243A	Material	:
	Due Date	: 05/05/2009
Written By :	Qty:	1 Um: Each
Checked & Approved By : <u>JUD 09.04.29</u>		
Comment :		
Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ		
Est Rev: O 06.02.28 Added paperwork EC		
Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM		
Est Rev:Q 09-03-19 rev.f as per IIN DD verified by:EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 09.05.21



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

S 02/05/21

2.0 D25001190 Ext'n -I' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B 476 438

D M 9-5-11

3.0 D2596 Web, 205 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B 476 79

Pm 09-05-12 (1)

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

M 9-5-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:01:25 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 47598

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 09-05-11

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

N 9-5-12

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M111081

Sikaflex expire date: 10-01-20

Start Time: 8:45 Date: 09-05-12

Fin Time: 7:00 Date: 09-05-13

Jim 09-05-12 (1)

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

ET 09-05-13

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

AWM 9-5-13 (1)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 47598

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/13 (X)

10.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B43504

09/05/13

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B-46434

20 ANM  
9-5-13

12.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M110972

09-5-13

3-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M110972

09-5-13

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

U  
9-5-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 47598

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8 09/05/15 (X)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/15 (X)

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BP/ MD 09/05/19 (X)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15  
320°C  
9:45 BP/ MD 09/05/20 (X)

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-20 (X)

18.0 D2855 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 342343

del

19.0 AN35A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100188

del

09-05-20 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47598

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M109632

20

21.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Insert

Batch: M110511

21

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

BOLT

Batch: M111668

22

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

washer

Batch: M111668

23

24.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1345827

24

25.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1347818

25

26.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: 1347317

26

09-05-20

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47598

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1346183

JP

28.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1346441

JP

29.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1346888

JP

30.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1347013

JP

31.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

O-Ring

Batch: 1329908

JP

32.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Plug

Batch: 1346435

JP

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before

installing wearplates

A/R

Sikaflex-291

1111081

JP

09-05-20

RC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 47598

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1-Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M111081  
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M111013

*gff 09-05-20*

34.0

QC5

INSPECT WORK TO CURRENT STEP



*506/521*



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



*12*

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: 22

PPP Rev: 1

*9/5/20*

*50*

36.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/05/20*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 09.05.22*

*B4 7.598*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY RH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED  
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41598

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Diagram illustrating the grinding locations for the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

DRILL PRIOR TO D2855 CAP  
INSTALLATION (2 PLACES)

AN3-5A BOLT (1)  
AN960JD10L WASHER (1)  
(2 PLACES)

D2855 CAP

SEAL WITH SIKAFLEX-241/-291

0.40

UNCO  
SUBI  
NO  
W  
1

D2579 SPACER  
 D2596 WEB (REF)  
 AL57-1032-130 (REF)  
 (TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY  
 PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
 1. CHAMFER HOLE 0.050 X 45°  
 2. INSERT D2579 SPACER (20 PLACES)  
 3. WELD INTO PLACE AND GRIND FLUSH  
 4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

37.50

DISTANCE TO AFT END OF D2596 WEB

3

7

1.750

1.750

#0.508 (TYP.) (40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)

7 EQUAL SPACES

8.188 PITCH

38.0

91.500

190.0 (D2500-1)

[illegible]

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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<b>DART</b>		<b>DART AEROSPACE LTD.</b> WAINSBURY, ONTARIO, CANADA	
DRAWING NO. D2580		REV. 1 SHEET 2 OF 3	
TITLE 205 SKIDTIRE ASSEMBLY		SCALE 1:2	



RELEASED  
07 Dec 28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating the rear view of the engine cover assembly. The diagram shows the following components and their locations:

- #0.208 DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Two small circles indicating the locations for drilling holes.
- SEAL WITH SIKAFLEX-241/-291**: A dashed rectangular area indicating the location for applying sealant.
- AN3-5A BOLT (1)**: A bolt located at the bottom center of the cover.
- AN960J10L WASHER (1) (2 PLACES)**: Two washers located on either side of the bolt.
- D2855 CAP**: The cap itself, shown as a dashed rectangular area.
- SEE NOTE ii)**: A reference to a note in the manual.

D2579 SPACER

D2596 WEB (REF)

7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER PERFO

1. CHA
2. INS
3. WEI
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO  $\phi 0.437$  X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50

DISTANCE TO AFT END OF D2596 WEB

38.0

REFER TO DETAIL A

8.750

17.375

26.000

34.188

91.500

190.0 (D2500-1)

1.750

1.750

#0.508 (TYP.) (40 PLACES)

57.313 (REF) 7 EQUAL SPACES 8.188 PITCH

REFER TO DETAIL E

(MAKE FROM D2580-1 DRILLING DETAIL)

Technical drawing of a curved pipe section. The drawing shows a horizontal pipe with a curved end. Key dimensions and callouts include:

- Overall length: 51.340
- Distance from left end to first hole: 5.985
- Distance between first and second holes: 5.338 (REF)
- Distance from second hole to third hole: 3.630 (REF)
- Distance from third hole to fourth hole: 39.580
- Distance from fourth hole to end: 5.915
- Hole diameter:  $\phi 0.508$  (8 PLACES)
- End hole diameter:  $\phi 0.640$
- End angle: 20.0°
- Distance between hole and tangent point (left): 1.0
- Distance between hole and tangent point (right): 1.0
- Overall distance from left tangent point to right tangent point: 32.0 ± 1.0
- Left tangent point offset: 1.4
- Right tangent point offset: 1.1
- Callout 4: Points to the left tangent point and the end of the pipe.

**AFT VIEW ASSEMBLY DETAIL**

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN

DRAWN BY

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PH
CHECKED <i>[Signature]</i>
DATE 07.02.23

	APPROVED
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DRAWING NO  
02580

REV. D  
SHEET 3 OF 3

TITLE
205 SKIDTUBE ASSEMBLY

SCALE  
1:24

NO. 199

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: D205 570598  
Part number: D205 563 011  
Description: 205 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Richard Date of Test Coupon 09.04.27  
Welder Barclay Elliott Date of Test Coupon 09.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld